

Date: Friday, 13/03/2009 4:51:10 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46488
 Estimate Number : 10829
 P.O. Number :
 This Issue : 13/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 43479

Drawing Name : 02.750 SUPPORT

Part Number : D28931
 Drawing Number : D2893 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 20/03/2009 Qty: 20 Um: Each

Written By :
 Checked & Approved By : JUL 09.03.13

Comment : Est: C 02.11.26 Reformat; Added P/O KJ
 est D 06.04.19 removed alodine EC
 Est Rev:E Added priming as per Rev B 07-04-30 JLM
 est F 08.03.19 Re-format EC verified by: DD
 Est Rev:G 08-05-15 add QC14 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

DSK078

D2893-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)
 D2893-1 TURNING DETAIL
 Batch: B43870

mm F 09/03/20

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS 1
 Machine as per Folio FA081
 Tumble & Deburr

mm F 09/03/20 / JL 09/03/23

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT ALL DIM TO DIM SHEET

mm F 09/03/20 / JL 09/03/23

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/03/23

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
 Mask Inside Bore for Priming

(x20)

START TIME:

8:45

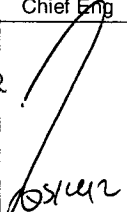

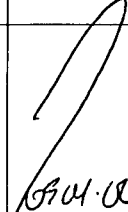
U20/FL

09/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2893-1 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/04/15

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46488</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/20	2.0	overall messer are off because part move because tool broke. could not re-take original origin. R.C process		2 piece scrap No Replace	mmj- 09/03/20	09/04/09 J.L		

NOTE: Date & initial all entries

Date: Friday, 13/03/2009 4:51:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 46488

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 400°
FINISH TIME: 9:15

ma Ed.

09/03/24

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(28)

Comment: INSPECT POWDER COAT

BR 09-03-24

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

RT 09-03-30

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

09-03-31 (28)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 09-03-31

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mf 09-04-14

DART AEROSPACE LTD		Work Order: 460488
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 X	2 X	3	4	5
HAAS Section								
AA	2.985	3.005		2.990	2.990	2.993	2.993	2.994
AB	0.440	0.460				.440	.440	.440
AC	0.125	0.160				.130	.130	.140
AD	0.040	0.060				.051	.051	.051
AE	0.188	0.193				.190	.190	.190
AF	0.125	0.160		.143	.140	.144	.140	.140
AG	0.140	0.160				.153	.159	.153
AH	1.360	1.400				1.367	1.368	1.372
AI	0.040	0.060				.049	.051	.049
AJ	1.190	1.230				1.212	1.212	1.214
AK	0.010	0.020				.015	.015	.015
AL	0.053	0.073				.063	.063	.063
AM	0.240	0.260				.250	.250	.250
AN	2.518	2.538				2.530	2.525	2.526
AO	84.39	90.39				87.39	87.39	87.39
AP	0.261	0.266				.263	.263	.263
AQ	0.053	0.073				.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: JL **Date:** 09/03/21

Audited by: SF **Date:** 09/04/23

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46488
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	27	38	49	510
HAAS Section								
AA	2.985	3.005		2.995	2.993	2.993	2.992	2.993
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.139	.140	.141
AD	0.040	0.060		.051	.052	.051	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.151	.150	.149	.152	.152
AH	1.360	1.400		1.370	1.370	1.372	1.372	1.372
AI	0.040	0.060		.048	.048	.049	.051	.048
AJ	1.190	1.230		1.212	1.213	1.215	1.216	1.214
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.526	2.523	2.525	2.524	2.525
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	.263
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L.
 Date: 09/03/21

Audited by: J.P.
 Date: 09/03/23

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 440488
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.993	2.993	2.993	2.993	2.993
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.051	.051	.051	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.152	.153	.151	.152	.152
AH	1.360	1.400		1.373	1.372	1.372	1.372	1.372
AI	0.040	0.060		.051	.045	.050	.047	.049
AJ	1.190	1.230		1.218	1.210	1.215	1.215	1.215
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.526	2.527	2.523	2.524	2.525
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	.263
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L.
 Date: 09/03/22

Audited by: J.S.
 Date: 09/03/23

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46488
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

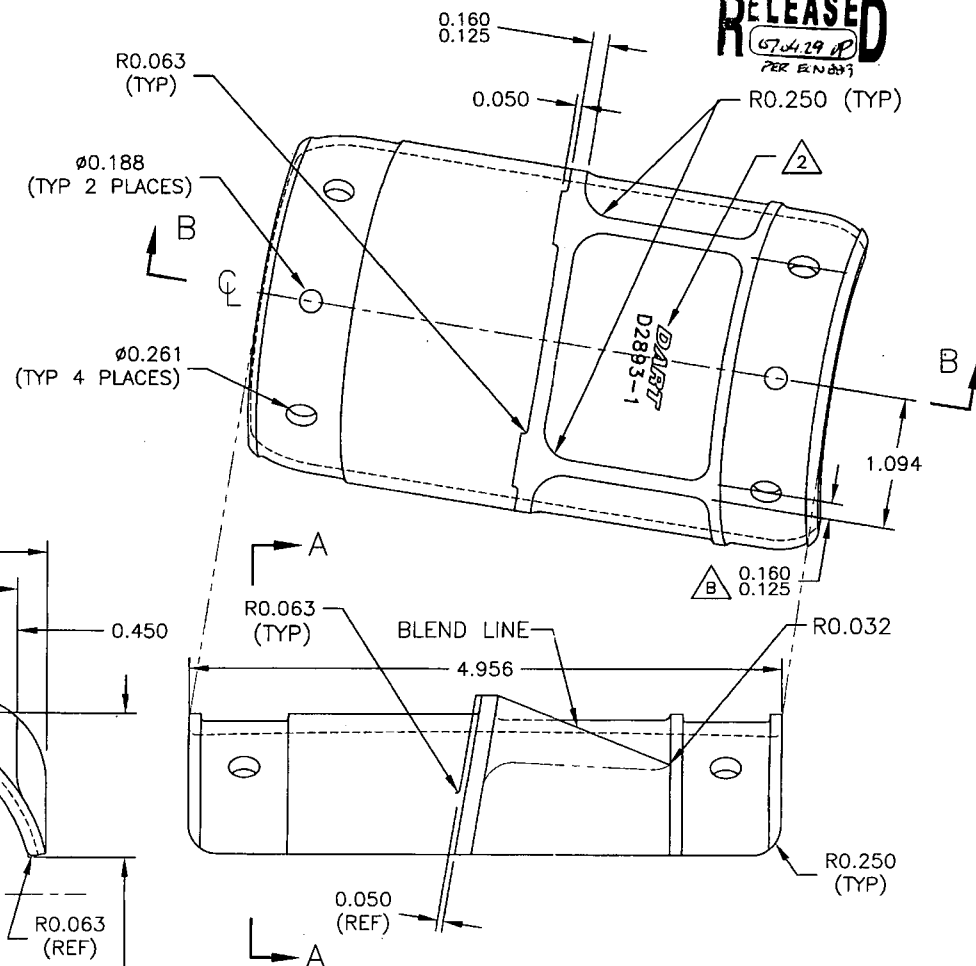
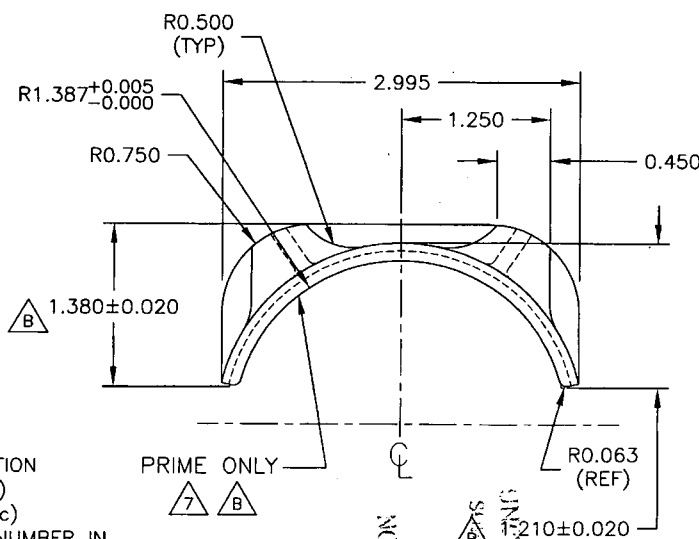
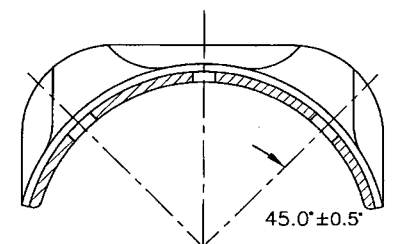
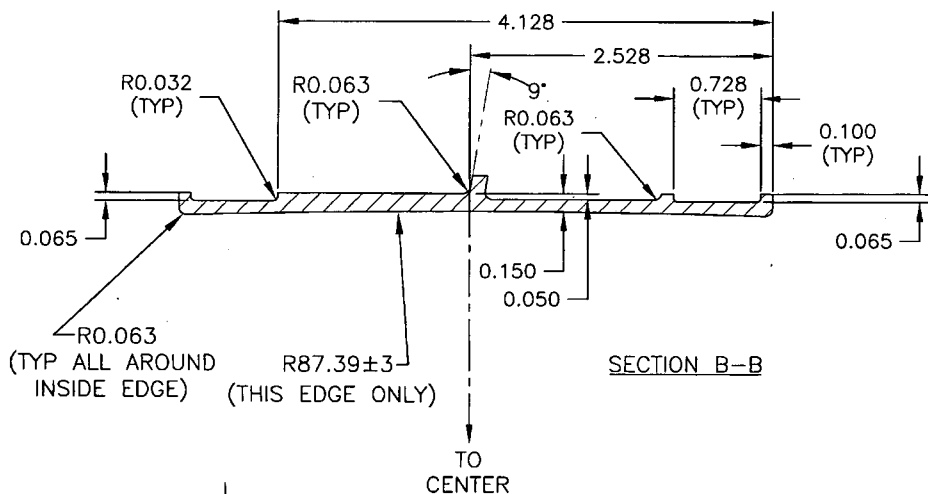
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.993	2.994	2.994	2.994	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.050	.051	.052	.052	.051
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.153	.152	.150	.152	.152
AH	1.360	1.400		1.372	1.372	1.373	1.375	1.375
AI	0.040	0.060		.048	.047	.048	.049	.051
AJ	1.190	1.230		1.215	1.213	1.215	1.218	1.216
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.526	2.527	2.526	2.526	2.526
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	.263
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: JL **Date:** 09/03/23

Audited by: [Signature] **Date:** 09/03/23

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	[Signature]



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

NO WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 ENGINEERING
 RETURN TO
 SHOP COPY

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B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	97	DRAWN BY 97
CHECKED	97	APPROVED 97
DATE	07.03.16	TITLE
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		D2893
		REV. B
		SHEET 1 OF 1
		SCALE
		1:1